

Date: Monday, 11/19/2007 4:06:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 STEP END PLATE
 Job Number : 35887
 Estimate Number : 11015
 P.O. Number : N/A Part Number : D267334
 This Issue : 11/19/2007 S.O. No. : N/A Drawing Number : D2673 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 32404 Material : NA
 Due Date : 12/15/2007 Qty: 200 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est. C 02-01-14 Removed deburr and inspect level 5 NG/EC
 Est Rev:D Now 6061-T6 06-06-23 JLM
 Est Rev:C Now on Waterjet 07-05-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.1913 sf(s)/Unit Total : 38.2620 sf(s)

6061-T6 .080 Sheet

(M6061T6S080)

Note: 1 Blank makes 2

Material Batch

M103755 X 90 = 17.217
 M103961 X 70 = 13.391
~~M103556~~ X 40 = 7.652
 M104186

HB 07-11-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2673

Dwg Rev: B

Prog Rev: B

HB 07-11-21

2-Deburr if necessary

[Signature] 07/11/23 (200)

(200)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-11-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

25P019 [Signature] 07/11/23

counted
 (1200)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 21/1/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 STEP END PLATE

Job Number: 35887

Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *in A 2*

Nov. 11. 26 (200)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Nov 11/26 (200)

Job Completion



U 11.11.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
QA: N/C Closed: _____ **Date:** _____

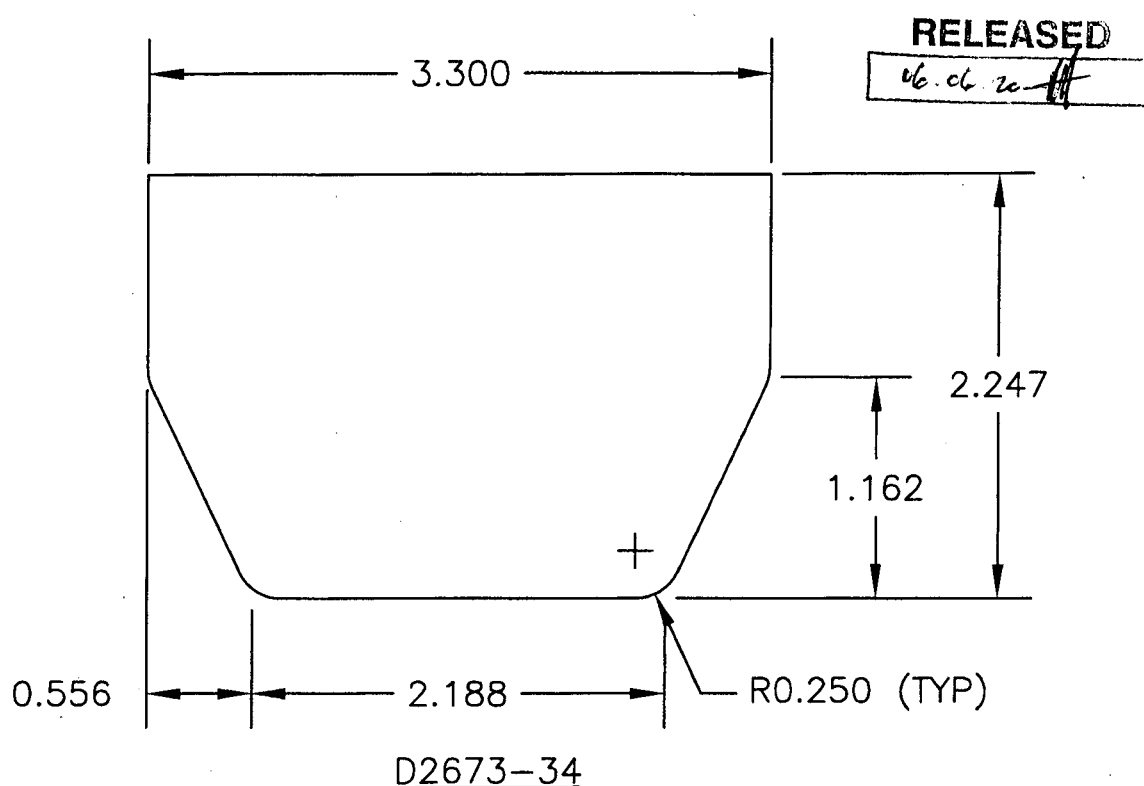
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED 	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE	SCALE 1:1
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°



NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35887

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